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D2144
Job Sheet 201776



Part No: D2144

Job Qty: 6 pcs

Part Name: Hinge Doubler



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/10/19

Job Tracking No:

Due Date: 10/21/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV D IPP: D 04.05.06 Reformat KJ/RF IPP Rev:E Now on Waterjet 06-10-15 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	6 pcs		10/21/19	0.00	0.33	Waterjet - Flow		02/19/10/16
110	QC 2	6 pcs		10/21/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		02/19/10/16
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

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120 QC 8	6 pcs	10/21/19	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	OCT 17 2019
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
130 Small Fab - 2 - B4B	6 pcs	10/21/19	0.00 0.23	Small Fab - 1 - B4B	
				Small Fab - 2 - B4B	DAS 40
				Small Fab - 3 - B4B	30
				Small Fab - 4 - B4B	9-89
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
				Small Fab - 8 - B4B	
140 Small Fab - Brake NC - B4B	6 pcs	10/21/19	0.01 0.41	Small Fab - Brake - 1 - B4B	DAS 30
				Small Fab - Brake - 2 - B4B	9-89
				Small Fab - Brake - 3 - B4B	
150 QC 5	6 pcs	10/21/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	

https://www.plexonline.com/be667820-cba9-49ce-8963-65ada09f754a/Plexus_Control/Report_Viewer_2.asp?URL=../Part/Job_Sheet.asp&Report=Tru... 3/5

					QC 3 - 58		
					QC 3 - 59		
					QC 3 - 68		
					QC 3 - 9		
					QC 3 - 40		NOV 06 2019
					QC 3 - 19		
					QC 3 - 43		
					QC 3 - 24		
					QC 3 - 61		
					QC 3 - 81		
210	Packaging 3-1 - Stock - B4B	6	10/21/19	0.00 0.00	Packaging 3 - 1 - B4B		
	pcs				Packaging 3 - 2 - B4B		
					Packaging 3 - 3 - B4B		
					Packaging 3 - 4 - B4B		
					Packaging 3 - 5 - B4B		
					Packaging 3 - 6 - B4B		
					Packaging 3 - 7 - B4B		
					Packaging 3 - 8 - B4B		
					Packaging 3 - 9 - B4B		
					Packaging 3 - 10 - B4B		
					Packaging 3 - 11 - B4B		
					Packaging 3 - 12 - B4B		
					Packaging 3 - 13 - B4B		
					Packaging 3 - 14 - B4B		
					Packaging 3 - 15 - B4B		
					Packaging 3 - 16 - B4B		
					Packaging 3 - 17 - B4B		
					Packaging 3 - 18 - B4B		
					Packaging 3 - 19 - B4B		
					Packaging 3 - 20 - B4B		
					Packaging 3 - 21 - B4B		
					Packaging 3 - 22 - B4B		
					Packaging 3 - 23 - B4B		
					Packaging 3 - 24 - B4B		
					Packaging 3 - 25 - B4B		
					Packaging 3 - 26 - B4B		
					Packaging 3 - 27 - B4B		
					Packaging 3 - 28 - B4B		
					Packaging 3 - 29 - B4B		
					Packaging 3 - 30 - B4B		
					Packaging 3 - 31 - B4B		
					Packaging 3 - 32 - B4B		
					Packaging 3 - 33 - B4B		
					Packaging 3 - 34 - B4B		
					Packaging 3 - 35 - B4B		
					Packaging 3 - 36 - B4B		
220	QC 21 - SA	6	10/21/19	0.00 0.00	QC 21 - SA - 21		
	pcs				QC 21 - SA - 70		
					QC 21 - SA - 53		

Part Op 100 - 1-Cut as per Dwg D2144
 Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB)
 120 - (QC8- Inspect parts - second check)
 130 - Deburr if necessary
 140 - (Bend/Assemble as per dwg) Form as per Dwg D2144 Rev: _____
 150 - (QC5- Inspect part completeness to step on W/O)
 160 - (Weld per dwg A/R S.S. rod Batch: _____) 1- Weld corner as per Dwg D2144 & QSI 004 2- Grind flush
 170 - (QC9- Inspect visual per QSI004- Fusion Welds)
 180 - (QC5- Inspect part completeness to step on W/O)
 190 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: _____ FINISH TIME: _____
 200 - (QC3- Inspect Part Finish)

10/10/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

210 - (Identify as per dwg & Stock Location: _____)
220 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S16GA	304/316 Sheet .063	.5670 sf (.0945 ea)	100-Waterjet - Flow - 1	3200442

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S16GA	1	392	0

Part Specifications

Specifications could not be found.

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DART AEROSPACE LTD		Work Order: 201776
Description: Hinge Bracket		Part Number: D2144
Inspection Dwg: D2144	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.381	+/-0.010	3.380	1		VDC02	
3.022	+/-0.010	3.021	1			
2.468	+/-0.010	2.469	1			
1.913	+/-0.010	1.915	1			
1.555	+/-0.010	1.554	1			
4.126	+/-0.010	4.128	1			
3.465	+/-0.010	3.466	1			
0.340	+/-0.010	0.339	1			
0.625	+/-0.010	0.624	1			
1.000	+/-0.010	0.999	1			
1.083	+/-0.010	1.081	1			
1.660	+/-0.010	1.659	1			
2.312	+/-0.010	2.314	1			
2.844	+/-0.010	2.845	1			
3.294	+/-0.010	3.296	1			
Ø0.257	+0.006/-0.001	Ø.258	1			
Ø0.171	+0.005/-0.001	Ø.173	1			
Ø0.320	+0.006/-0.001	Ø.319	1			
0.354	+/-0.010	0.356	1			
0.063	+/-0.010	0.056	1			

Measured by: [Signature]	Audited by: DAS 40 9-89	Prototype Approval:	N/A
Date: 19/10/16	Date: OCT 17 2019	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.05.31	New Issue	KJ/JLM	[Signature]



Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐

NCR No. _____

Job: _____

Part No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐

DEPARTMENT/PROCESS

Skid-tube ☐
Machining ☐
Large Fab ☐

Cross tube ☐
Small Fab ☐
Finishing ☐

Eng. (Non-AW) ☐
Prod. Eng. Coord. ☐
Rec/Store/Packaging ☐

Engineering ☐
Water Jet ☐
Supplier ☐
Quality ☐

Date: _____

Sequence #: _____

QTY Affected: _____

MRB (QS1042)

Description Work Order Deviation

Disposition

Completed By _____

Lead hand / Supervisor _____

QC / QA Coordinator _____

Root Cause

Operator ☐
Manufacturing Process ☐
Equip/Tooling ☐
Handling/Preservation ☐
Material ☐
Product Improvement ☐
Process Improvement ☐
Human Factors ☐

FAULT CATEGORY

Pressure/Forced ☐
Bending ☐
Crushing ☐
Cracks ☐
Crimp/kink/Ripple/Wave/Twist ☐
Marks/Chatter ☐
Mislabeled ☐
Contamination ☐
Misaligned/off center ☐
BOM/Route ☐
Broken/Damage/Defect ☐
Incomplete/Unclear Instructions ☐
Drill Holes ☐
Fit/Function ☐

Power Loss/Surge ☐
Folio/Program ☐
Grain Direction ☐
Weld ☐
Wrong Stock Pulled ☐
Out of Sequence ☐
Off-set/Set-up ☐
Positioned Wrong ☐
Outside Tolerance ☐
Drawing ☐
Finish ☐
Part Lost/Missing ☐
Misread ☐

Other/Details: _____